

ASAP

Work Order ID 84076

84076

Wednesday, May 02, 2012 1:06:14 PM

Item ID: D3699-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support Assembly

Start Date: 5/2/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/8/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

12-05-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3699	Rev A								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3699Dwg Rev: A

Prog Rev: A

6061 0050

grain direction along 9.00"

2- Deburr if necessary

1312-57

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1312-57

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

5/7/05/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00				9			12/05/09
Brake NC	Bend as per Dwg D3699								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				(X)			
Quality Control									
150	Small Fab	0.00							
150									
Small Fab	Memo	0.00				9X			12/05/10
Small Fab	1-counter sink holes as per dwg D3699								

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				9			MJ 12.05.10
160									
QC	Memo	0.00							
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00				9			MJ 12.5.10
170									
HandFinish	Memo	0.00							
Hand Finishing									
180	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				9X			M-F 12/6/11
180									
Powdercoat	Memo	0.00							
Powder Coating									

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

320°F

8:15
8:45

M117338

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	Pick Kit	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	Small Fab	0.00							
210									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D3699								

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Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

220

1


12.05.14

230

Q

12/5/148

240

12/5/15 

mf

12-05-14

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Picklist Print

Wednesday, May 02, 2012 1:06:18 PM

Page 1

Work Order ID: 84076

84076

Parent Item: D3699-041

D3699-041

Parent Item Name: Support Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:ec
IPP Rev:B 08-07-14 revA as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3		Purchased		No		100	Each	3,563.000	2	8			
MS20426AD3-3									**				

Rivet

Location

Loc Qty

Loc Code

ST316

3563

119109

611

121011

2517

19099

435

M6061T6S.050

Purchased

No

210

sf

222.6640

0.4569

1.923789

M6061T6S 050

**

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

021

144

1211920

144

MAT021

78.664

114799

63.664

114993

15

114799

1812-5-7

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 2

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Parent Item: D3699-041

D3699-041

Parent Item Name: Support Assembly

Start Date: 5/2/2012

Required Date: 5/8/2012

Start Qty: 4.00

Required Qty: 4.00

MS21059L3

Purchased

No

210

Each

357.0000

1

**

9 12/15/14

MS21059L3

Nut Plate

Location

Loc Qty

Loc Code

302

100

121185

100

ST301

28

118614

8

119546

20

ST302

229

120308

13

120833

1

121011

15

121444

100

121524

100

9

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	Y4026
Description: Support, LH		Part Number:	D3699-1
Inspection Dwg: D3699	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	L		V RB7	
Ø0.180	+0.005/-0.001	.181	2		V	
Ø0.238	+0.005/-0.001	.237	2		V	
Ø1.525	+0.012/-0.001	1.526	2		V	
0.36	+/-0.030	.366	L		V	
0.62	+/-0.030	.620	2		V	
0.96	+/-0.030	.96	L		V	
2.21	+/-0.030	2.208	L		V	
4.12	+/-0.030	4.121	L		V	
8.95	+/-0.030	8.956	L		PROW 501	
1.925	+/-0.010	1.926	2		V	
8.61	+/-0.030	8.613	2		P	
2.62	+/-0.030	2.619	2		V	
0.344	+/-0.010	.344	2		V	
0.688	+/-0.010	.687	2		V	
0.64	+/-0.030	.641	2		V	
2.66	+/-0.030	2.666	2		V	
5.75	+/-0.030	5.756	2		V	
6.41	+/-0.030	6.412	2		P	
0.300	+/-0.010	.300	2		V	
0.923	+/-0.010	.923	2		V	
0.050	+/-0.010	.051	2		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-5-7	Date: 12/6/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	

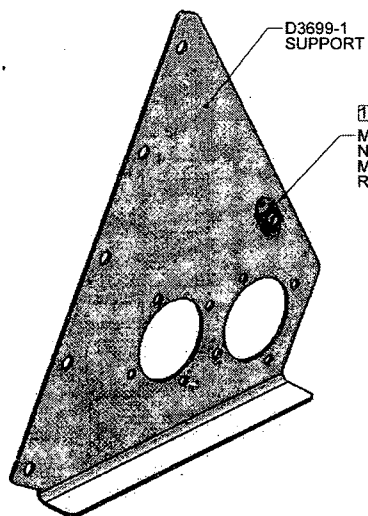
W/O:		WORK ORDER CHANGES					
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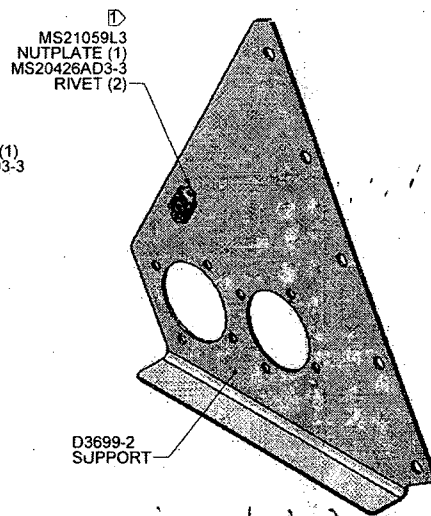
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D3699-041 SUPPORT ASSEMBLY



D3699-042 SUPPORT ASSEMBLY

NOTES:

- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK $\phi 0.098$ HOLES ON D3699-1/2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84074

11-05-2

RELEASED
08.07.12

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JE</i>		
CHECKED	<i>CP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MA</i>	D3699	SHEET 1 OF 2
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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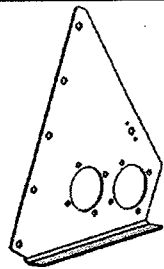
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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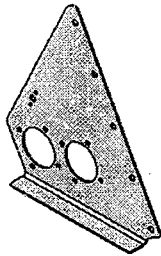
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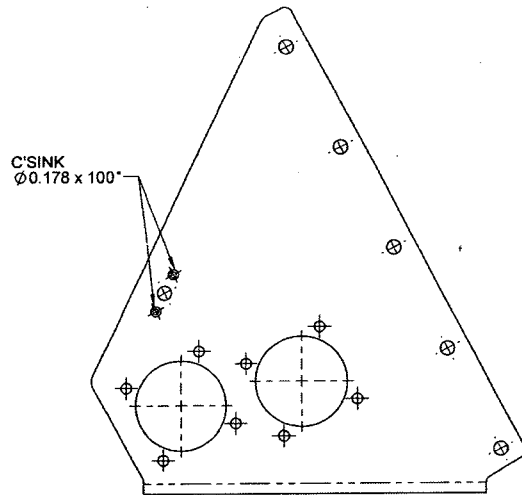
84079



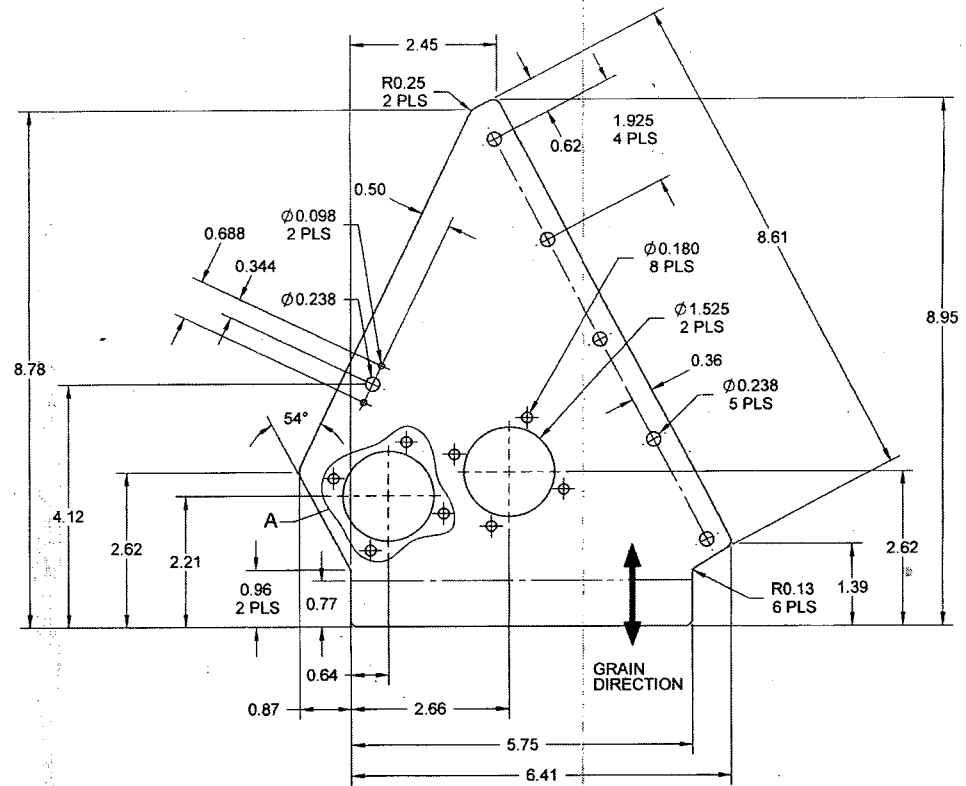
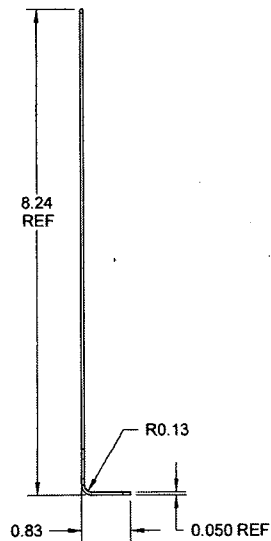
D3699-1 LH SUPPORT



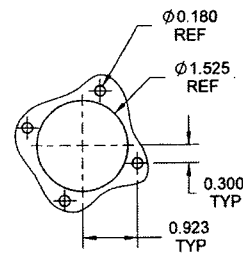
D3699-2 RH SUPPORT



**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**



D3699-1F FLAT PATTERN





DETAIL A

RELEASED
08-07-08

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK
(REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
DATE	08.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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